

Date: Tuesday, 4/29/2008 8:23:06 AM  
 User: David Duva

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GROUND PLATE
Job Number : 38859	
Estimate Number : 13282	
P.O. Number :	Part Number : D37971
This Issue : 4/29/2008 S.O. No. :	Drawing Number : D3797 PRELIM
Prsht Rev. : NC	Project Number : N/A
First Issue : 4/29/2008 Type : SMALL / MED FAB	Drawing Revision : PRELIM
Previous Run :	Material :
Written By : <u>DAVID DUVA</u> 08/04/30	Due Date : 5/6/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment : Est Rev:A 08-04-25 new issue DD verified by:ec	

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



PRELIMINARY ISSUE

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S050 6061-T6 .050 Sheet



Pho →  
 Last Page

Comment: Qty.: 0.4797 sf(s)/Unit Total : 0.4797 sf(s)  
 6061T6 aluminium sheet .050" thick  
 (M6061T6S050)  
 Batch: 104186 IB 8-4-30

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3797  
 Dwg Rev: A  
 Prog Rev: A

IB 8-4-30

①

2- Deburr if necessary IB 8-4-30

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-4-30

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

ENGINEERING  
APPROVAL

Comment: SECOND CHECK

08/04/30 DAVID DUVA 08.05.06

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

N/A 08.05.06

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Part Number: D37971

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 0054.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

N/A CP 08-05-06

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A CP 08-05-06

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

give to David Duval

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08-05-13 Prototype

Job Completion



Already  
Scanned

Change to  
W/O #00235

W 08-05-09  
PARTS ACCEPTABLE  
TO D3797 Rev. C  
CP 08-09-06

- PROTOTYPE CP  
PAPERWORK  
FOR GLARE SHIELD  
- CAN BE FILED

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-776-011

Job #: 00235

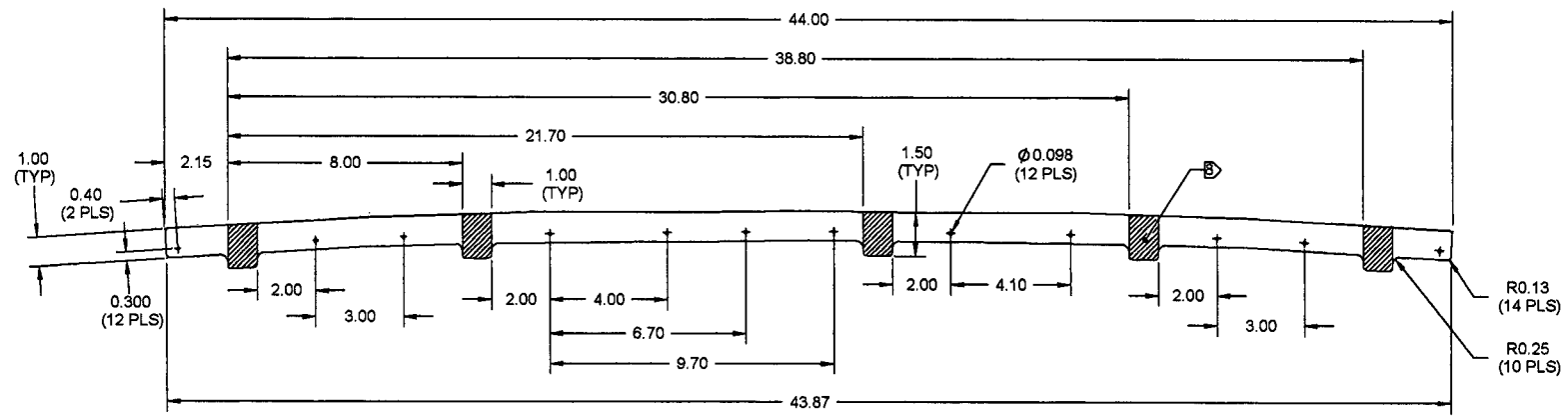
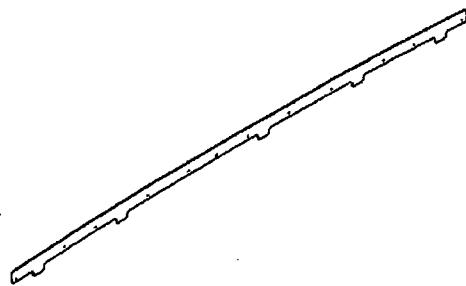
Date: 25-Apr-08

Product Name: B412 Glareshield

Requested By: MP for RF

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3697-1	Tube	31/03/2008	y	09-May-08		
1	D3797-1	Ground Plate	31/03/2008	y	09-May-08		
1	D3697-3	Support Plate LH	31/03/2008	y	09-May-08		
1	D3697-4	Support Plate RH	31/03/2008	y	09-May-08		
1	D3698-1	Support Angle	31/03/2008	y	09-May-08		
1	D3690-1	Glareshield	31/03/2008	y	09-May-08		
1	D3697-041	Tube assy	31/03/2008	y	09-May-08		
1	D3699-041	Support Assy	31/03/2008	y	09-May-08		
1	D3699-042	Support Assy	31/03/2008	y	09-May-08		
1	D3690-041	Glareshield Assy	31/03/2008	y	09-May-08		



**D3797-1 GROUND PLATE**

**PRELIMINARY ISSUE**

*MP 08-04-25*

- NOTES:**
- 1) MATERIAL: 5052-H32 (QQ-A-250/8) ALUMINUM SHEET 0.050 THICK (REF. DART SPEC. MM5052H32S.050)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.08 lbs
  - 8) MASK HATCHED AREAS (5 PLS) ON BOTH SIDES OF THE PART PRIOR TO PAINTING

A NEW ISSUE		RF	08.04.24
REV.	DESCRIPTION		BY DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3797	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		GROUND PLATE	1:4
DATE	08.04.24	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 38859
Description: GROUND PLATE		Part Number: D3797-1
Inspection Dwg: D3797-1 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	x			
44.00	+/- .030	44.00	x			
43.87	+/- .030	43.87	x			
.300	+/- .010	.300	x			
1.00	+/- .030	1.009	x			
.40	+/- .030	.400	x			
8.00	+/- .030	8.00	x			
1.50	+/- .030	1.508	x			
1.00	+/- .030	.999	x			
2.00	+/- .030	2.013	x			
3.00	+/- .030	3.001	x			
4.00	+/- .030	3.998	x			
6.70	+/- .030	6.70	x			
9.70	+/- .030	9.70	x			
4.10	+/- .030	4.101	x			
21.70	+/- .030	21.70	x			
30.80	+/- .030	30.80	x			
38.80	+/- .030	38.80	x			
11.050	+/- .030	.048	x			






Measured by: LB	Audited by: J	Prototype Approval: P
Date: 8-4-36	Date: 08/04/36	Date: 08.05.06

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/08	2.0.	welded in wrong orientation Didn't pay attention to Dwg. Final Dwg.	 RSM/2	Scrap and Destroy. And replace qty ① 31 104/86	 08/05/08	 08/05/08	 RSM/2	 08/05/08

NOTE: Date & initial all entries

# Receiving Report

Date: 07/04/20

Batch No: 1104186

Supplier: Magna

Dart P/O: 3581

Packing Slip: Yes / No /  
 Invoice: Yes / No /  
 Receipt: Cash / Cr /

Release Note Attached: Yes / No / N/A /  
 Waybill Attached: Yes / No / N/A /  
 Shipment Complete: Yes / No / N/A /  
 QC6 Inspection / N/A /  
 Work Order / N/A /

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
	6061-T6 Alum	40	0	0	40	
	Fillet 3/4x3					

Initials of receiver (if shipment OK) Level 12 PS

Production/Admin:

Date: 07/04/20  
 Received/Costing: R/P 4401-4417  
 Initial: CS

Location: \_\_\_\_\_

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

Sub-Total  
 G.S.T.

468.00  
 28.00

**TOTAL →**

496.00

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.  
 LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME  
 AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.  
 ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.  
 THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD  
 BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

## ଉପସ୍ଥାପନା

Tel: (0347) 77-9  
 Fax: (0347) 24-  
[www.bba.com](http://www.bba.com)

# Novelis

48277/278/279  
11/11/11

45275 / 45276 /

Abmahnungsprozessorgans  
Inspektion Certificate  
Certificate of Recognition  
EN 10204-3;  
EN 10204-3;  
EN 10204-3;  
EN 10204-3;

**ALFA**  
**84352232-8**

## Summary

~~WFO-QD-A-250/11, (1987)~~

[illegible]

**Chemische Ausstattungsleistung in Gaudis-garten mit charakteristischer Konposition in Prozenten der Gesamtanbaufläche**

**CONTRACTS TO BE AWARDED**

Case No./Date of meeting	Meeting	25	26	27	28	29	30	31	32
100 089426	05/02/25	0.53	0.34	0.26	0.09	0.05	0.03	0.01	0.02
100 059435	05/01/21	0.53	0.36	0.28	0.08	0.04	0.06	0.01	0.01
100 059436	05/02/27	0.52	0.34	0.26	0.08	0.05	0.09	0.01	0.02
100 059156	05/02/24	0.51	0.38	0.30	0.07	0.05	0.08	0.01	0.02

**Elektronische Eigenschaften  
Mechanische Eigenschaften  
Chemische Eigenschaften**

[illegible]

This certificate has been made out by me and that's why it isn't signed.

## Methodology

**5.05-05**

Zurückgenommen von 150475 TMRB, 1850 64001, 23445 u. 046649 94071  
Die Abhängen sind 772, Gleichzeitigkeit Nordost PMA, von Westung, Etwas Punkt  
Wird das Aufsteigen der Erde.

**219. D. White**  
**1000 1/2 St. NW**  
**Washington, D.C.**

## About the author